

Work Order ID 67480

PRELIMINARY ISSUE



Page 1

Tuesday, March 22, 2011 2:42:27 PM

Item ID: D4323-13

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Ceiling, Center Fwd

Start Date: 3/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:



Reference:

Approvals:

Process Plan: H

Date: 11-03-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4323	PAI A <u>H</u>								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>PAI</u> Prog Rev: <u>PAI</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B 11-3-23

EP 11/03/23

①

B 11-3-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Work Order ID 67480




Tuesday, March 22, 2011 2:42:27 PM



Page 2

Item ID: D4323-13 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Ceiling, Center Fwd
Start Date: 3/22/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 3/23/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	Sulost/23 @ inspected to PAJ Dm only						
130  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00	EAGUE 4/13/23 (1)						
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00	11/5/16 JH R02370						

POSITIVE RECALL
EFFECTIVE 11/03/13 AUTH L
RELEASED W P DATE 11/05/13

11/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 22, 2011 2:42:33 PM

Page 1

Work Order ID: 67480

Parent Item: D4323-13

Parent Item Name: Ceiling, Center Fwd



Start Date: 3/22/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.14 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	948.0376	4.6	4.842105			



6185 KYDEX .080"



11-3-23

Location

therm

109703

116576

Loc Qty

948.037564

81.189115

866.848449

Loc Code

116576

①

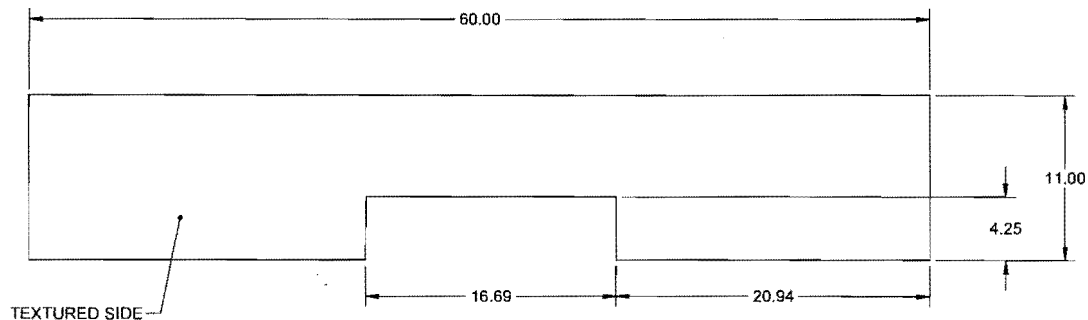
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

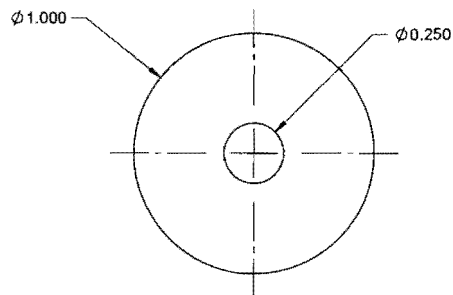
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D4323-13 CEILING, CENTER FWD



D4323-15 SPACER

NOTES:

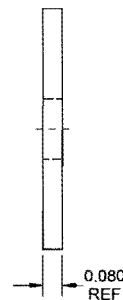
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 2.05 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. PA5
MFG. APPR.		D4323	SHEET 9 OF 13
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	11.02.09	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**PRELIMINARY
ISSUE**

#67480

0.080
REF



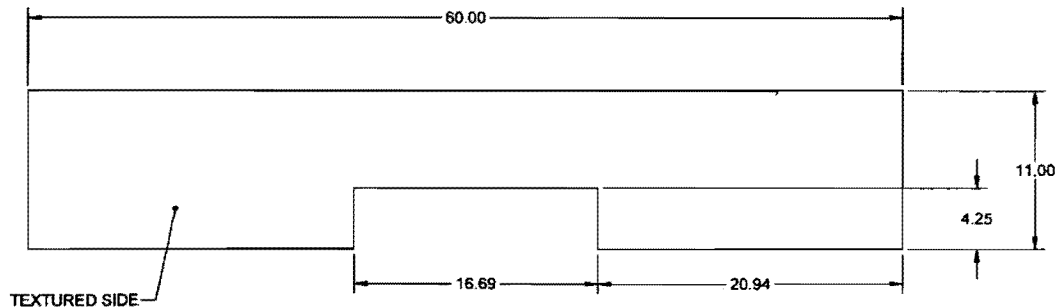
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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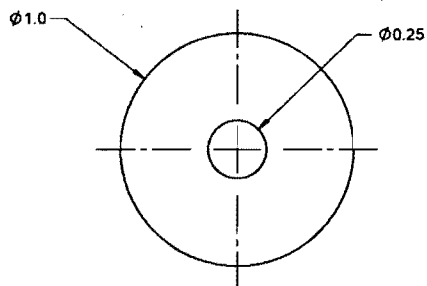
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries









D4323-13 CEILING, CENTER FWD



D4323-15 SPACER

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: -13 = 2.33 lbs
-15 = 0.003 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4323	SHEET 9 OF 15
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
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RELEASED
2011-05-10
WJ

67480

1813
769
1044